

Work Order ID 87796

87796

Page 1

July-12-12 9:00:45 AM

Item ID: D105-674-011G

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube, Grey

Start Date: 7/12/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2966	Rev A2

100		0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo								
	Photocopy bluefile & type labels per PPP		D105-674-011G	CHG002					

DAS 16 2-83 *relate* *for MJS 12-7-25*

130		0.00							
130	Skidtubes								
Skidtubes		0.00							
Skidtubes	Memo								
	** Pull D2966-1 bent **								

1-Cut Aft end at 107.06" using DT8185D
2-Deburr ends
3-Drill Aft Cap holes using DT8678
4-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.
5-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.
6-Open Aft Cap holes using #6 drill
7-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.
8-Deburr holes.
9-Open remaining (16) crossbolt holes to Ø0.500

SAD 12-07-12

B87796

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole. *AK m120164*

2-Grind Fwd Cap welds flush

SAD 12-07-16

8/2/07/16

150

QC10- Inspect visual per QSI004- ground welds

0.00

150

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing									
180	QC7-Inspect Chemical Conversion Coat	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Skidtubes	0.00							
190									
Skidtubes	Memo	0.00							
Skidtubes	1-Open crossbolt holes to finish size as per Dwg D2966 2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966 3-Deburr holes inside & outside, blow out chips								

DAS
03
2-89

DP 12-7-17

>

DL 12/02/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Revision ID: Stop ***NS2***
 Item Name: Skidtube, Grey
 Start Date: 7/12/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00							
200									
Skidtubes	Memo	0.00							
Skidtubes	1-Bond Web in place per QSI 015. (Ensure holes line up) Pick: A/R Sikaflex-291 batch: <u>120130</u> Sikaflex expiry date: <u>13-3-14</u> start time: <u>18:45</u> end time: <u>12-07-19</u>								
	2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill. Pick: A/R Aluminum Rod batch: <u>M120164/M122324</u>								
	3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.								
	4-Grind welds flush as per Dwg D2966								
210	QC10- Inspect visual per QSI004- ground welds	0.00							
210									
QC	Memo	0.00							
Quality Control									

DAS
16
9-2

12/07/19

DC 12/07/18

BE 12-07-19

DD 12-7-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00							
220									
QC	Memo	0.00							
Quality Control									
225	Touch up alodine	0.00							
225									
HandFinish	Memo	0.00							
Hand Finishing									
226	Assemble as per dwg	0.00							
226									
HandFinish	Memo	0.00							
Hand Finishing	INSTALL ALS7-1032-130, MS27039-1-08, AN960JD10L IN TWO PLACES BEFORE POWDERCOATING								



Handwritten signature/initials

Handwritten signature/initials and date 12/27/19

Handwritten signature/initials

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 7/20/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description:	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* Powdercoat Powder Coating W121279	Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3 Memo START TIME: 2:00 OVEN TEMPERATURE: 320°F FINISH TIME: 2:30	0.00 0.00				1X	Ø		MK 12/07/19
240 *240* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1x	f	ll	12/07/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

250

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

1-Inspect for foreign objects as per QSI 024

2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side.

Pick:

QtyPart NumberDescriptionBatch

A/RSikaflex-291 M121531

Sikaflex expiry date: 12/08

3-Wing Walk as per Dwg D2966 and QSI 005 4.4

Batch: 11122320

10 12/10/12

260

260

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

DAS 16 12/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
270									
QC	Memo	0.00							
Quality Control	*****ENSURE INSERT ARE AT LOCATION (6) AS PER DWG D2966*****								
280	Pick Kit	0.00							
280									
Packaging	Memo	0.00							
Packaging									
290	QC4- 100% Inspect kits for completeness	0.00							
290									
QC	Memo	0.00							
Quality Control									

DAS 16 9-83 12/14/12

1

12/07/25 JB

DAS 16 9-83 12/14/26

KL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 7/20/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D105-674-011G Location: _____								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

Per 7/26/12

12/7/30

ME 12-07-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 87796

Parent Item: D105-674-011G

Start Date: 7/12/12

Required Date: 7/20/12

Parent Item Name: Skidtube, Grey

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.07.07New IssueKJ/JLM

IPP Rev:B 10.06.09 remove seq110 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2966-1-BENT Skidtube Assembly 105		Manufactured	No			130	Each	2.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		2							
				83295		1							
				83783		1							
D2964 Cap		Manufactured	No			140	Each	29.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		12							
				83064		12							
				LG002		17							
				74719		17							
D2976 BO 105 Skidtube I Beam		Manufactured	No			200	Each	0.0000	1				
D2971 Cross Bolt Spacer		Manufactured	No			200	Each	22.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		22							
				74720		22							
D2973 Cross Bolt Spacer		Manufactured	No			200	Each	64.0000	7	7			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		64							
				14636		14							
				80092		50							

SAD 12/07/12

①

BE12/07/16

12/07/18

①

BE12/07/19

BE12/07/19

7

W/O:		WORK ORDER CHANGES					
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Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

D2965

Cap, 105 Skidtube

Manufactured No

250 Each 44.0000

1

12/07/12

Location

Loc Qty

Loc Code

FP002

44

1387959

✓

71371

4

80089

40

D2970-1

Wearplate

Manufactured No

250 Each 8.0000

1

12/07/12

Location

Loc Qty

Loc Code

FP001

8

48213

3

80090

5

✓

D2970-3

Wearplate

Manufactured No

250 Each 9.0000

1

12/07/12

Location

Loc Qty

Loc Code

FP001

1

48214

1

FP002

8

80091

8

✓

D3176-1

Bushing

Manufactured No

250 Each 6.0000

1

12/07/12

Location

Loc Qty

Loc Code

ST032

6

37586

6

✓

D3176-3

Nut

Manufactured No

250 Each 9.0000

1

12/07/12

Location

Loc Qty

Loc Code

ST032

9

44896

9

✓

July-12-12 9:00:44 AM

Shop Packet Print

Page 2

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Parent Item: D105-674-011G
Parent Item Name: Skidtube, Grey

Start Date: 7/12/12 Required Date: 7/20/12
Start Qty: 1.00 Required Qty: 1.00

ALS7-1032-130 Purchased No

250 Each 1,520.0000

36 HL 36 12/07/23

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	51	
117717	27	
118966	22	
119775	2	
ST282	1469	
119530	73	
120181	12	
<u>121444</u>	1384	

X36

MS27039-1-08 Purchased No

250 Each 1,168.0000

26 HL 26 12/07/23

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST291	1168	
117423	81	
119075	1	
120308	166	
121011	43	
121243	500	
<u>121708</u>	377	

X26

AN960JD10L NAS1149D0332J Purchased No

250 Each 0.0000
N1121011

28 (X28) 28 HL 12/07/23

Washer

MS27039-1-09 Purchased No

250 Each 267.0000

2 HL 2 12/07/23

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	93	
<u>18057</u>	93	
ST291	174	
111650	174	

X2

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Parent Item Name: Skidtube, Grey

Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

8 D2972 Bushing	Manufactured	No	290	Each	27.0000	6	6	JB	
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
		ST022	27						
		33544	4						
		44160	23					44160	
8 D2974 Packer	Manufactured	No	290	Each	37.0000	1	1	JB	
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
		ST022	37						
		71997	37					71997	
8 D2975 Wearshoe	Manufactured	No	290	Each	4.0000	2	2	JB	
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
		ST497A	2						
		74721	2						
		ST500	2						
		80093	2					80093	
8 AN4-51A Bolt	Purchased	No	290	Each	526.0000	3	3	JB	
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
		362	96						
		121181	96						
		ST361	430						
		119798	30						
		122151	400					122151	
8 AN960JD10L Washer	Purchased	No	290	Each	0.0000	8	8	JB	12/07/25
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
		NAS1149D0332J						121908	

July-12-12 9:00:44 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-12-12 9:00:44 AM

Page 5

Work Order ID: 87796

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 7/12/12

Required Date: 7/20/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Nut

Purchased

No

290

Each

914.0000

3

3

Location

Loc Qty

Loc Code

ST300

914

119075

116

121011

193

121444

605

MS27039-1-08

Screw

Purchased

No

290

Each

1,168.0000

8

8

Location

Loc Qty

Loc Code

ST291

1168

117423

81

119075

1

120308

166

121011

43

121243

500

121708

377

12/444

122452

JB 12/07/25

July-12-12 9:00:45 AM

Shop Packet Print

Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT



al087796

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



01.01.24
CP 01.01.30

A2	02.10.30	ADD D3176-1/-3	# UP
A1	01.01.24	CHANGE COLOR TO BLACK SANDTEX	# UP

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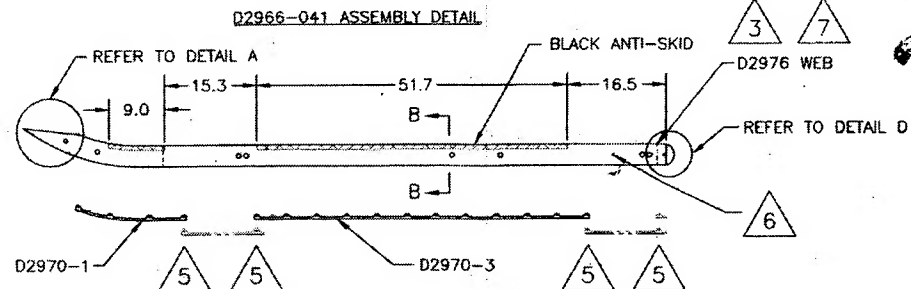
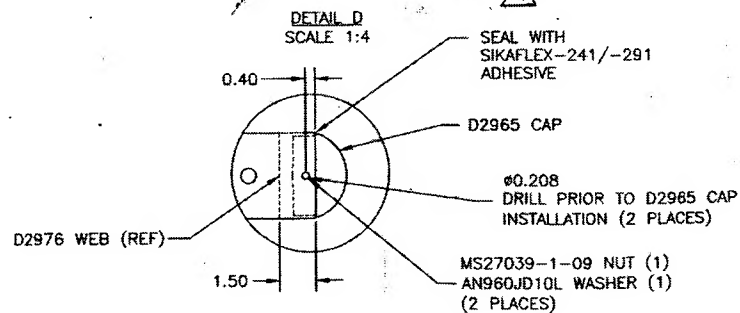
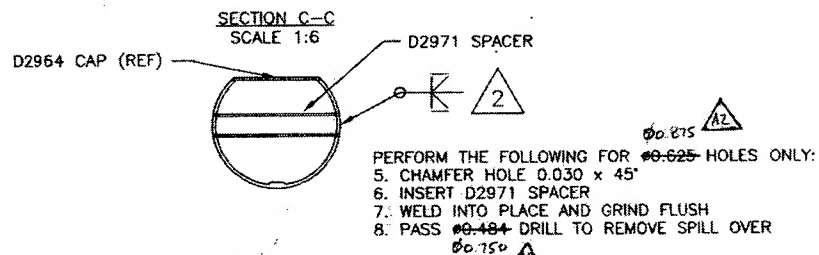
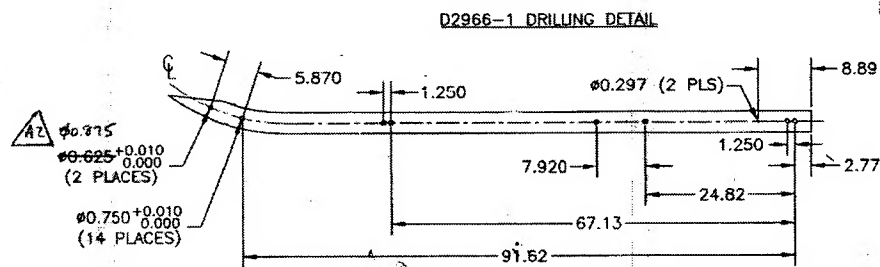
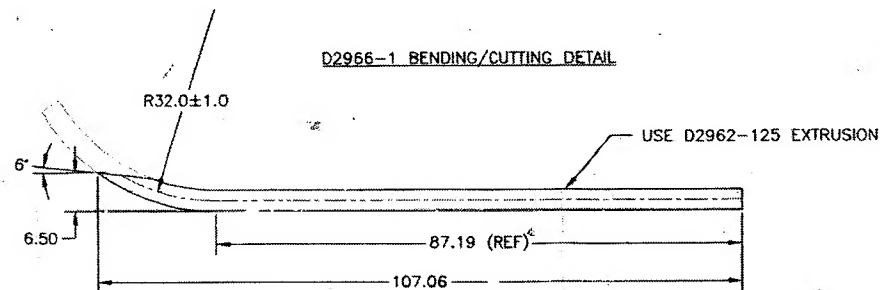
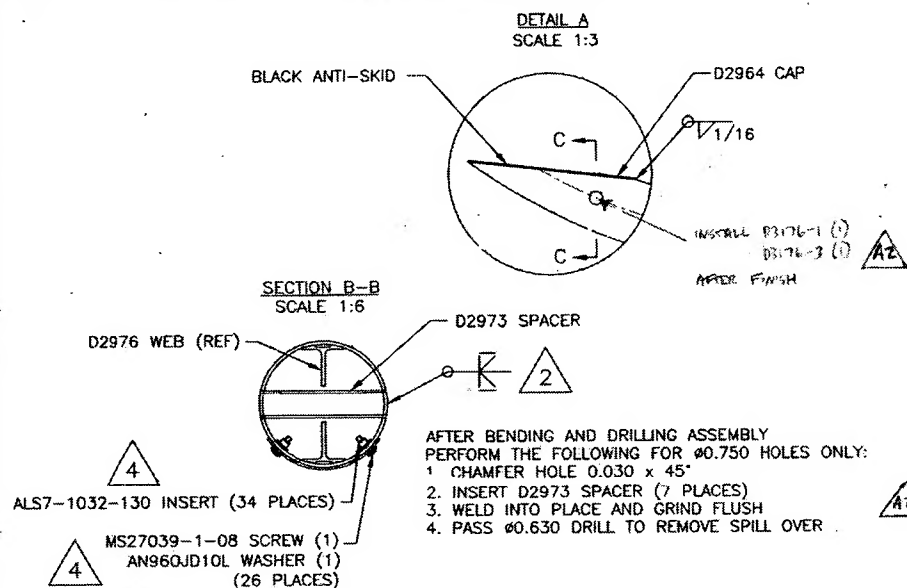
W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED A	APPROVED A	DRAWING NO. D2966	SHEET 2 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY		SCALE 1:20	

RELEASED
00-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

NO. 259

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B68574
Part number: D105-674-0110
Description: 105
Welding Process: Tig~~[]~~ Mig~~[]~~
Base material: Aluminum
Current: AC~~[]~~ DC~~[]~~

TEST REQUIREMENTS AND RESULTS

Visual: pass~~[]~~ fail~~[]~~
Penetration: pass~~[]~~ fail~~[]~~

UNACCEPTABLE

Cracks: pass~~[]~~ fail~~[]~~
Undercut: pass~~[]~~ fail~~[]~~
Pin holes: pass~~[]~~ fail~~[]~~
Overlap (cold lap): pass~~[]~~ fail~~[]~~
Porosity (surface): pass~~[]~~ fail~~[]~~
Coloration: pass~~[]~~ fail~~[]~~

Qualifier Lat. Davis Date of Test Coupon 11.06.30
Welder Barclay Elliott Date of Test Coupon 11.06.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld